



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3915-041

Job Sheet 167837



Part No: D3915-041

Job Qty: 1 ea

Part Name: Light Lid Assembly, Long Basket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/7/17

Job Tracking No:

Due Date: 12/11/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

000312

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/8/17	0.00	0.00	Start Up Large Fab2		DC 2018-01-24
100	Large Fab	1 pcs		12/9/17	0.00	3.33	Large Fab 2	5 hr	18-1-18
110	QC	1 pcs		12/9/17	0.00	0.00	QC9		18-0-27
120	QC	1 pcs		12/9/17	0.00	0.00	QC5		18-0-27
130	HandFinish	1 pcs		12/9/17	0.00	1.00	HandFinish1		2018/01/29 7:30
140	Large Fab	1 pcs		12/9/17	0.00	3.33	Large Fab 2		18-1-30
150	QC	1 pcs		12/9/17	0.00	0.00	QC9		CPC
155	QC	1 pcs		12/9/17	0.00	0.00	QC6		CPC
157	HandFinish	1 pcs		12/9/17	0.00	1.00	HandFinish1		18-01-30
160	Powdercoat	1 pcs		12/9/17	0.00	0.83	Powdercoat1		18-01-31
170	QC	1 pcs		12/9/17	0.00	0.00	QC3		18-1-31
180	HandFinish	1 pcs		12/11/17	0.00	0.81	HandFinish4		18-1-31
190	QC	1 pcs		12/11/17	0.00	0.00	QC5		18-1-31
200	Packaging	1 pcs		12/11/17	0.00	0.00	Packaging3		
210	QC21-SA	1 Ea		12/11/17	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make
Descriptions: a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with

weld. ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND
ALODINE OUT OF BASKET LID FRAME**** 2- weld hinge, label plate and Mounting plates as per dwg D3915

130 - ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***

140 - 1- weld (4) corners

155 - ***inspect fit of lid with base***

157 - 1- realodine corners ***do not acid etch***

160 - 1- touch up corner with alodine only 2- Plug holes prior to

180 - 1- Install webbing as per dwg 2- Install placard and label as per dwg

M 138467 START: 7:30 OUT: 320° FINISH: 8:00.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2957-161750-22x	4	18	0	0
	D3915-162730	2	6	0	0
	D4016-5152120	3	8	0	0
	D4019-3162731	3	11	0	0
	D4035-0473033155	2	2	0	0
	D4056-1157507	1	8	0	0
	D2728-1	1	0	0	0
180-HandFinish	D4029-041 F157452	1	3	0	0
	MS20600-AD4W4	34	686	0	0

5025738 -7

NAS1149DN949J

34

211

0

0

F138246

Part Specifications

Specifications could not be found.

Plex 11/7/17 10:56 AM dart.poulin.mario

DART
AEROSPACE
S034844

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Light Lid Assembly, Long Basket

PART NO: D3915-041

Original Serial #: S034844

Revision:

Operation:

Change No:

Start up Operation 01/24/18

Job No: 167837

Master Unit 000031



Job No

167837